



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3155-041
Job Sheet 198439



Part No: D3155-041

Job Qty: 2 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/29/19

Job Tracking No:

Due Date: 9/3/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG REV D IPP B 03.02.03 Reformat KJ/RF IPP Rev:C As per Rev D 07-06-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs		9/3/19	0.00	0.08	Bandsaw - 1		M.V. 2019/09/11
110	HAAS 4 Axis - B4B	2 pcs		9/3/19	1.00	1.00	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B		
120	QC 2	2 pcs		9/3/19	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62		M.V. 2019/09/11

DAS
64
9-89

DAS
64
9-89

Plex 7/29/19 1:14 PM Dart.Renwick.Jennifer

**DAS
64
9-89**

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	mm. 20/9/09
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	2 pcs	9/3/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	VHS 19/9/12
				QC 8 - 57	
150 Handfinish - 1-1 Chemical-B4B	2 pcs	9/3/19	0.00 0.10	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 12 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 3	2 pcs	9/3/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
Plex 7/29/19 1:14 PM Dart.Renwick.Jennife					

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

https://www.plexonline.com/2870f91a-9780-40d6-8c3f-ef5a1e444ebb/Plexus_Control/Report_Viewer_2.asp?URL=https://www.plexonline.com/2870f91... 3/4

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
200	QC 21 - SA	2	9/3/19	0.00 0.00	QC 21 - SA - 21 ✓
Closed wo only <i>JK</i> pcs					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Bandsaw) Cut blanks: (2.000" x 1.000") x 6.87" Long Bar Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA315 and Dwg D3155 2-Deburr and Tumble 3-Identify as D3155-1 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 150 - (Chemical Conversion Coat per QSI005 4.1) 160 - (QC3- Inspect Part Finish) 170 - (Small Fab) Press fit bushing as per Dwg D3155 180 - (QC5- Inspect part completeness to step on W/O) 190 - (Identify as per dwg & Stock Location: _____) 200 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	1.1666 ft (.5833 ea)	100-Bandsaw - 1	5110499	
D3155-3	Bushing	4 pcs (2 ea)	170-Small Fab - 2 - B4B	856337	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.000X02.000	1	17	0	
170-Small Fab - 2 - B4B	D3155-3	4	9	0	
Part Specifications					
Specifications could not be found.					

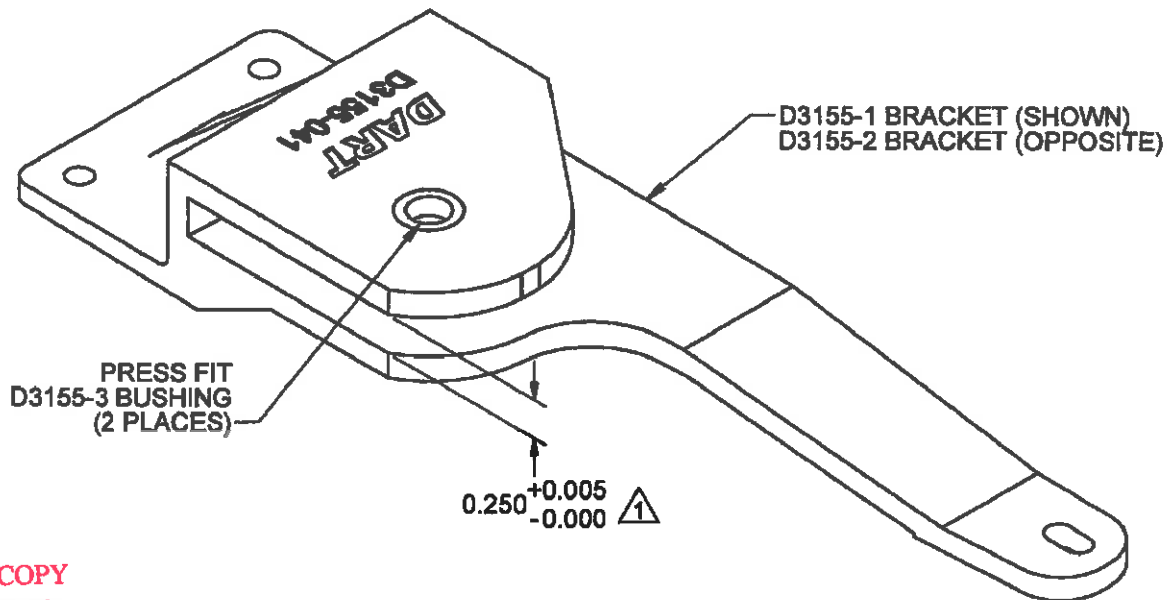
Plex 7/29/19 1:14 PM Dart.Renwick.Jennifer



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3155	REV. D SHEET 1 OF 3
DATE 07.01.18	TITLE BRACKET ASSEMBLY		SCALE 1:1
REV	DATE	DESCRIPTION	
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	
D	07.01.18	ON D3155-1/-2, 0.699 DIM WAS REMOVED; 0.887 WAS 0.882; 3.150 WAS 3.148; ADD 0.250 DIM +0.005/-0.000	

RELEASED

07.06.04 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198439

D3155-041 BRACKET ASSEMBLY
(SHOWN, REPLACE PREMIER P/N B30-23000-11)
D3155-042 BRACKET ASSEMBLY
(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3155-041	BRACKET ASSEMBLY
	X	D3155-042	BRACKET ASSEMBLY
1		D3155-1	BRACKET
	1	D3155-2	BRACKET
2	2	D3155-3	BUSHING

NOTE:

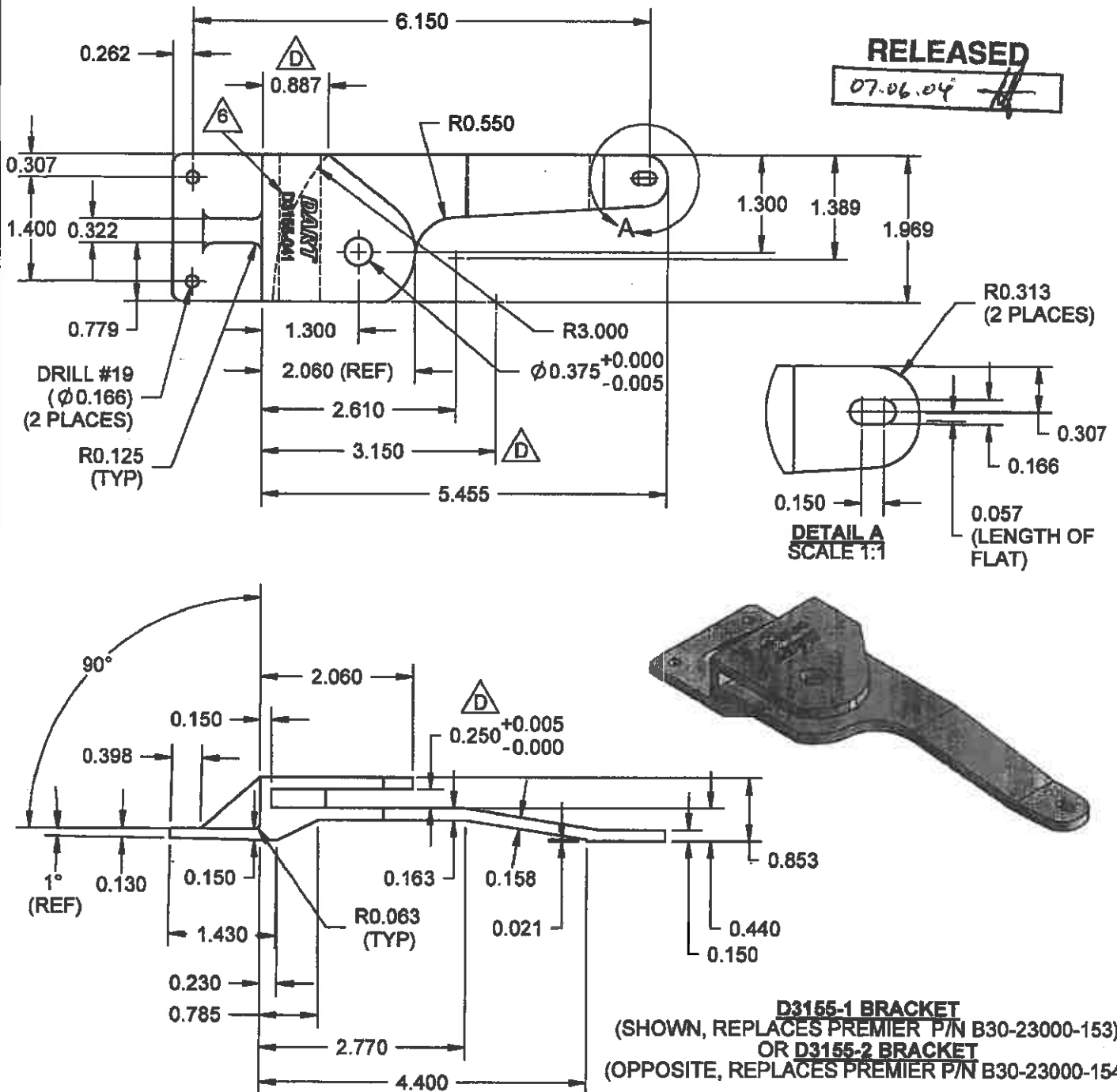
⚠ MAINTAIN THE 0.250^{+0.005}_{-0.000} DIMENSION AFTER PRESS FITTING THE BUSHING.

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3155	REV. D SHEET 2 OF 3
DATE 07.01.18	TITLE BRACKET ASSEMBLY		SCALE 1:2



NOTES:

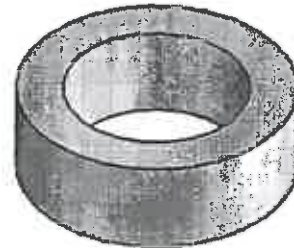
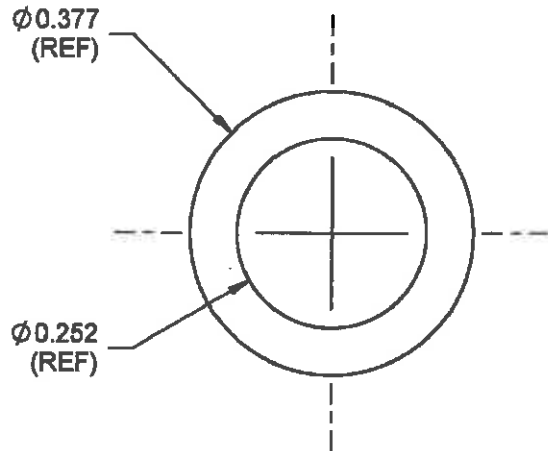
- 1) MATERIAL: ALUMINUM BAR 6061-T6/-T651 PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117 OR AMS 4128 OR AMS 4115 OR AMS 4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN TO MAX DEPTH OF 0.010 WITH A MIN RAD OF 0.010

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DESIGN <i>df</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>df</i>	DRAWING NO. D3155	REV. D SHEET 3 OF 3
DATE 07.01.18		TITLE BRACKET ASSEMBLY	SCALE 4:1



RELEASED

07.06.04 *df*



D3155-3 BUSHING

NOTES:

- 1) MATERIAL: MAKE FROM SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3065-5DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3155-1
Inspection Dwg: D3155	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.166	+0.005/-0.001	.166 Ø	✓		lin gauge	
Ø0.375	+0.000/-0.005	.375 Ø	✓		lin gauge	
6.150	+/-0.010	6.156	✓		high gauge	
0.262	+/-0.010	.268	✓		vernier	
1.400	+/-0.010	1.399	✓		vernier	
0.307	+/-0.010	.315	✓		vernier	
1.969	+/-0.010	1.970	✓		vernier	
0.322	+/-0.010	.322	✓		vernier	
0.779	+/-0.010	.770	✓		vernier	
0.166	+/-0.010	.166	✓		vernier	
0.307	+/-0.010	.316	✓		high gauge	
1.300	+/-0.010	1.310	✓		high gauge	
0.130	+/-0.010	.122	✓		vernier	
0.150	+/-0.010	.152	✓		vernier	
0.150	+/-0.010	.153	✓		vernier	
0.853	+/-0.010	.845	✓		high gauge	
0.163	+/-0.010	.164	✓		vernier	
R0.063	+/-0.010	R0.063	✓		Go/No-Go	
5.455	+/-0.010	5.454	✓		high gauge	
4.600	+/-0.010					
2.060	+/-0.010	2.062	✓		high gauge	
0.021	+/-0.010	.025	✓		vernier	

Measured by: <i>MM</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 2019/09/11	Date: 19/9/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue P/O D3155-041	KJ/JLM	<i>[Signature]</i>